October-19-12 2:43:36 PM Item ID: 646,9501 Accept *N900040100* Setup Start **Revision ID:** Item Name: 206 Cable Cutter, High Start Date: 19/10/2012 Start Oty: 1.00 Cust Item ID: **Required Date: 02/11/2012** Reg'd Qty: 1.00 Customer: Reference: Start Run Process Plan: ML5 Date: \2 - \9 Tooling: Approvals: Date: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ Tool ID Tool# Operation Set Up/ Plan Reject Accept Reject Insp. Work Center ID Description **Run Hours** Qty Qty Number Stamp Code Draw Nbr **Revision Nbr** 646.9500 N/C 100 DAS DOCUMENT CONTROL *100* 27 DC 0.00 9-89 Memo Document Control Photocopy bluefile & type labels per PPP 646.9501 110 Pick Kit 0.00 *110* Packaging 0.00 Memo Packaging 120 QC4-100% Inspect kits for completeness 0.00 *120* DAS QC 0.00 Memo 27 Quality Control 9-89

B93

											DQA:	Da	te:	•
NCR: Y	res / N	o			WORK ORDER NON-	CO	NFOR	MANCE / UI	PDATE				7	
				-							QA Closed:	Da	te:	
Work Orde	nr:				DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
Part N					Rework Scrap			Skid-tube Machining	Crosstube Small Fab		4	Water Jet d. Eng. Coor.		Engineering Quality
NCR N	No				Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	_	Rec/Sto	re/Packaging Supplier	-	Other
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	Bendi	ng			Bend		Grain				Ovalized			Pressure/Forced
	Centr	e Not Conce	entric to	o/s	BOM/Route		Hardwa	re			Over/Under	tolerance		Temperature/Cure
	Crack	5			Broken/Damaged		Inspecti	on Incomplete			Part Incorre	ct		Weld
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] .	Cuffs				Contamination		Mainte	nance			Part Moved			-

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Quality Control

October-19-12 2:43:36 PM Item ID: 646.9501 Accept *N900040100* Setup Start **Revision ID:** Item Name: 206 Cable Cutter, High Start Date: 19/10/2012 Start Qty: 1.00 Cust Item ID: Required Date: 02/11/2012 Req'd Qty: 1.00 **Customer:** Reference: Run Start Approvals: Process Plan: Date: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Reject Tool# Reject Plan Accept Insp. Work Center ID Description Run Hours Qty Code Qty Number Stamp 130 0.00 Packaging 13-9-3 *130* Packaging 1 3 2 0.00 Memo Packaging Identify and pack for shipping as per PPP 646.9501 Location: 140 QC21- Final Inspection - Work Order Release 0.00 QC 0.00 Memo

VIII

13-9-03

											D	QA:	Dat	e:	•
NCR:	Yes	/ No				WORK ORDER NON-C	100	NFORM	ANCE / UF	PDATE				-	
											QA Clo	sed:	Dat	e:	
Work Orde	er.					DISPOSITION				AGAINST DE	PARTM	ENT,	PROCESS		•
Part l	-					Rework Scrap		ין	Skid-tube Machining	Crosstube Small Fab			Water Jet		Engineering Quality Quality
NCR I	No					Use-as-is Work Order Update		1	noforming Large Fab	Finishing Composite	кес/	Stor	e/Packaging Supplier		Other
Root					Descri	ption of work order update		Initial	A	ction	Sign	&		i	
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	\square	Cracks			L	Broken/Damaged		Inspecti	on Incomplete		Part Inc	orre	:t , ,		Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete	/Unclear	Part Los	st/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Mo	oved			
		Heat Trea	t			Countersink		Mislabe	led		Position	ned V	Vrong		
		Inspection	n Strip in	Tube		Cut Too Short	\prod	Misread			Power l	.oss/	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Picklist Print

October-19-12 2:43:40 PM

Work Order ID: 92036

92036

Parent Item:

646.9501

646 9501

Parent Item Name: 206 Cable Cutter, High

Start Date: 19/10/2012

Required Date: 02/11/2012

									5	Start Qty: 1.00		Require	d Qty; 1.0	00
	Comments: 1F	PP REV:A 12.08.	28 NEW ISSUE	DD V	/ERF:JLM									
	Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	- Status
ــــــــــــــــــــــــــــــــــــــ	*646.9601 *646 . 9601	* < mb	Manufactured	No .	 ,		110	Each	0.0000	**		9/25	3	
	Upper Gutter-Assembly 646.9602	*	Manufactured	No			110	Each	0.0000		0	_ { (<u>.ez</u> -v .		
	646.9810	1 DM2	Manufactured	No			110	Each	0.0000	₹	<u>&</u> (1)	970	7 	
	164619810 Deflector 647.0210	*543	Manufactured	No			110	Each	0.0000	**	$\frac{1}{2}$	9 32	3.0	
	*647 0240	* 345						2	0.000	**	B	3/44	06	NE
	647.0110 *冷<u>4</u>7 のり110 Roof Poubler	5 W	Manufactured	No	•		110	Each	0.0000	**	① M.;	1262	45	
	*647.0310 *647.0340	* a n	Manufactured	No			110	Each	0.0000	***	2) B50	ر شے ہ کی م		
	Channel 646.9910 *646.9910		Manufactured	No			110	Each	0.0000	**	4			
٦.	Struit 647.0112	SW)	Manufactured	No			110	Each	0.0000	8	B9_3 ③	01.57	- 6-	
	*647 0119	SW								**	139	2666		13/3/3

Page 1

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-O	O	NFORM	MANCE / UPD	DATE		<u> </u>	
,											QA Closed:	Date:	
Work Ord	er.					DISPOSITION	İ			AGAINST DE	PARTMENT	/PROCESS	
Part I	No.		-			Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					l	ption of work order update	1	nitial	Acti		Sign &		
Cause	,	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector
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Landi	ne G	ear				General	701	CATE	0011				
	$\overline{}$	Bending				Bend		Grain			Ovalized		Pressure/Forced
	\vdash	_	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re	<u> </u>	Over/Under	tolerance	Temperature/Cure
	Centre Not Concentric to O/S Cracks					Broken/Damaged		Inspecti	on Incomplete		Part Incorre		Weld
	Crushed/Crimped.					Burrs		Instruct	ions Incomplete/U	nclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved		_
		Heat Trea	t			Countersink		Mislabe	led		Positioned V	Vrong	_
		Inspection	n Strip in	Tube		Cut Too Short		Misread	i		Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes		Offset					
		Torque W	aves in E	xtrusio	n [Drawing		Out of 0	Calibration				
,		Turning S	equence			Finish		Out of S	Sequence				

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Picklist Print

October-19-12 2:43:40 PM

Work Order ID: 92036 *92036* Parent Item: 646.9501 *646 9501* Parent Item Name: 206 Cable Cutter. High Required Date: 02/11/2012 Start Date: 19/10/2012 Start Oty: 1.00 Required Qty: 1.00 647.0113 Manufactured No 110 Each 0.0000 647.0111 Manufactured No 110 Each 0.0000 647.0116 Manufactured No 110 Each 0.0000 64 20410 Manufactured No 110 0.0000 Each Tube 647.0114 Manufactured No 110 0.0000 Each Clip 647.0115 No 110 Manufactured Each 0.0000 Clip NAS1149FN832P Purchased No 110 Each 523,0000 111 23900 20 Washer Location Loc Qty Loc Code 275 198 122441 198 ST275 125 115158 125 ST294 200 123352 200

										DQA:	Date:	
NCR:	res / No				WORK ORDER NON-C	O	VFORM	MANCE / UPC	DATE	QA Closed:	Date:	
Work Orde	ar.				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	No				Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	ı	nitial	Acti	ion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector
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		Not Conce	ntric to C)/s	Bend BOM/Route		Grain Hardwa			Ovalized Over/Under	 	Pressure/Forced Temperature/Cure
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-	_	/Crimped	-	<u> </u>	Burrs	_	í	ions Incomplete/U	Inclear	Part Lost/Mi	ssing	Wrong Stock Pulled
}	Cuffs			\vdash	Countarial	-	Mainte		<u> </u>	Part Moved		
}	Heat Tre	eat on Strip in	Tubo	-	Countersink Cut Too Short	-	Mislabe Misread		<u> </u>	Positioned V Power Loss/		Other
}	Ripples		Tube		Drill Holes		Offset	,	<u> </u>	Jrower Loss/	ouge	Tomer

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

October-19-12 2:43:40 PM

Work Order ID: 92036

Parent Item:

NAS1149F0332P

646,9501

Parent Item Name: 206 Cable Cutter, High

92036

No

646 9501

Start Date: 19/10/2012

Required Date: 02/11/2012

Start Oty: 1.00

Required Qty: 1.00

1.274.0001

Loc Code

Purchased

WASHER

AN3-11A

Location Loc Oty 275 298 122441 298 ST275 776 117735 13 119225 8 121259 138

121825 14 122063 600 17317 3

110

110

ST295 123352 200 200 Each

Each

**

123759 28 .

123900 gB

Bolt

Purchased

Purchased No

No

Location Loc Oty ST351 346 110865 46 115457 100 123352 200 110 Each

500.0000

Location Loc Oty ST315 500

123352 500 Loc Code

Loc Code

123352

USE M\$21042E3

MS21042-3

October-19-12 2:43:40 PM

Shop Packet Print

Page 3

NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFORM	MANCE / UP	DATE			
								•			QA Closed:	Date:	
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	•
Part NCR	No.					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root		["	Descri	ption of work order update		Initial	Act	tion	Sign &		
Cause	_	Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
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	<u> </u>	Bending			<u> </u>	Bend		Grain			Ovalized		Pressure/Forced
	<u> </u>	Centre No	ot Concer	ntric to (D/S	BOM/Route		Hardwa			Over/Under) 	Temperature/Cure
	<u> </u>	Cracks			<u> </u>	Broken/Damaged	<u>_</u>	1	on Incomplete		Part Incorred	<u> </u>	Weld
	<u> </u>	Crushed/	Crimped.		ļ	Burrs	<u>_</u>	1	ions Incomplete/l	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs			<u> </u>	Contamination		Mainte			Part Moved		
	_	Heat Trea			ļ	Countersink		Mislabe			Positioned V		7
	<u> </u>	Inspection		Tube		Cut Too Short	\vdash	Misread	l	<u></u>	Power Loss/	Surge	Other
	\bigsqcup	Ripples in				Drill Holes	<u>_</u>	Offset					
		Torque W	aves in E	xtrusion	1	Drawing		Out of C	Calibration				

Out of Sequence

Outside Dimensions

DQA: _____ Date: ____

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

October-19-12 2:43:40 PM

Work Order ID: 92036		*9	2036*						
Parent Item: 646.9501			46 9501*						
Parent Item Name: 206 Cable	Cutter. High	•				Start Dat Start Qt	e: 19/10/2012	Required Date	
CCR264SS-3-06	Purchased	No		110	Each	100.0000		Required Qty	γ: 1.00
*CCR264SSE		,110		(10	Each	**	8 -	70	
	R		Location	Loc	<u>Qty</u>	Loc Code			
9 M	<i>></i>		ST327		100				
:			123023		100	_	12300	<i>13</i>	
MS21059L08	Purchased	No		110	Each	1,282,000	4 فمسؤل	_	
M\$210591-08	3			1		**	12409	3 10	h
	•		Location	Loc	<u>Oty</u>	Loc Code			ı
SM)		ST300		7				
			112314		7			_	
			ST314		400			_	
			123265		400			<u> </u>	
			ST316		875			<u> </u>	
	A		123100		775		_		
CR3213-4-05.CC	9	No	123352		100		<u> </u>		
Y	Purchased	190		110	Each	738.0000	6 26	1	
*CR3213-4-05) *		•			**			13-07-2
CI/)		<u>Location</u>	Loc	() t	Loc Code			
OM			ST328	LIK		Loc Code			01
			123301		600 600			_	
			ST331		138				
			108473		38			<u> </u>	
			108991		100		10899	7 7	

NCR:	Yes	/ No				WORK ORDER NON-C	O	NFORI	MANCE / UPI	DATE			
_											QA Closed:	Date:	
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	,
	•			 -		Rework]		Skid-tube	Crosstube]	Water Jet	Engineering
Part	No.					Scrap		1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is			noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR	No.		<u>.</u>			Work Order Update	j		Large Fab	Composite	J	Supplier	
Root					Descri	ption of work order update	Ī	Initial	Act	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Descr	ription	Date	Verification	QC Inspector
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Equip/Tooling	Ш		•]									
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Unapproved	H												
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		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	Crushed/Crimped.					Burrs		Instruct	ions Incomplete/l	Jnclear	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuffs					Contamination		Mainte	nance .	,	Part Moved		_
	Ш	Heat Trea	t			Countersink		Mislabe	led		Positioned V	Vrong	,
	\vdash	Inspection		Tube	<u> </u>	Cut Too Short		Misread	I		Power Loss/	Surge	Other
	Ш	Ripples in				Drill Holes	L	Offset					
	Ш	Torque W	aves in E	xtrusio	ı	Drawing	L	Out of 0	Calibration			<u></u>	
		Turning So	equence		1	Finish	1	Out of S	equence				

Outside Dimensions

Date: ___

DQA:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Finish Folio October-19-12 2:43:40 PM

Work Order ID: 92036

646.9501

Parent Item Name: 206 Cable Cutter. High

92036

646 9501

Location

Location

ST328

ST331

Location

ST328

ST331

123301

123301

104291

123301

113288

ST329

Start Date: 19/10/2012

Required Date: 02/11/2012

Start Qty: 1.00

Required Qty: 1.00

CR3213-4-6

Parent Item:

CR3213-4-4

CR3213-4-2

Purchased

Purchased

Purchased

No

No

No

110

110

110

400 . 400

Each

Loc Oty

Loc Oty

Loc Qty

1000

1000

19

19

400

400

10

10

Each

Each

400.0000

124.876 11

Loc Code

Loc Code

Loc Code

1,019.000 18

12330

October-19-12 2:43:40 PM

Shop Packet Print

Page 5

												DQA:		Date:	•	_
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORN	MANCE / UP	DATE		QA Closed:		Date:		
Work Ord	er.					DISPOSITION				AGAINST D	Εł	PARTMENT	/PROCESS	5		•
Part I NCR I	- No					Rework Scrap Use-as-is Work Order Update		M Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-		Water d. Eng. Co re/Packag Supp	or.	Engineering Quality Other	
Root			_		Descrip	ption of work order update		Initial	Act	tion		Sign &				•
Cause		Date	Step	Qty	c	or Non-conformance	Ct	nief Eng	Desc	ription		Date	Verifica	ation	QC Inspector	
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L						F	AUI	T CATE	GORY							_
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	∐′	Bending Centre No Cracks	ot Concer	ntric to ()/s	Bend BOM/Route Broken/Damaged		Grain Hardwai				Ovalized Over/Under		<u> </u>	Pressure/Forced Temperature/Cure	
	-	Crushed/0	Crimped,			Burrs	\vdash	1	on Incomplete ons Incomplete/I	Unclear	_	Part Incorred Part Lost/Mi		_	Weld Wrong Stock Pulled	
		Cuffs				Contamination		Mainte		<u> </u>	┙	Part Moved	-			
	اط	Heat Trea	t			Countersink		Mislabel	led			Positioned W	Vrong		_	
		nspection	n Strip in	Tube		Cut Too Short		Misread				Power Loss/	Surge		Other	_
	l li	Ripples in	Bend			Drill Holes		Offset			_					•

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

October-19-12 2:43:40 PM

Work Order ID: 92036

646.9501

92036

Parent Item Name: 206 Cable Cutter, High

646 9501

CR3213-4-3

MS21047-3

MS21042-08

Parent Item:

Purchased

No

110

Each

Start Qty: 1.00

Loc Code

1,050,000

Start Date: 19/10/2012

124976 20

Required Date: 02/11/2012

Required Qty: 1.00

Purchased

No

Location Loc Oty ST328 1000 123301 1000 ST331 50 116583 118503 120910 10 121243 30 110 Each

125,0000

125535 gs

NUT PLATE

Purchased No Location Loc Oty ST316 125 123268 50 123301 50 123352 25 110 Each

142.0000

Loc Code

*M\$21042_G USE MS21042L08

Sh 1843

Location Loc Oty ST300 42 103668 42 ST316 100 123352 100 Loc Code

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORI	MANCE / UPDATE				
											QA Closed:	Date:	
Work Ord	or.					DISPOSITION		ļ	AGA	INST DE	PARTMENT	/PROCESS	
WOR OIG	C1.		·			Rework	٦		Skid-tube Cross	tube	ļ	Water Jet	Engineering
Part I	۷o					Scrap	1] ,	——	l Fab	Pro	d. Eng. Coor.	Quality
	•••					Use-as-is	1	1	ĕ ⊢	hing		e/Packaging	Other
NCR I	Vo.					Work Order Update	1		Large Fab Compo	~—		Supplier	
							-	<u>. </u>					· · · · · · · · · · · · · · · · · · ·
Root					Desc	cription of work order update		Initial	Action		Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data			i	İ									
Equip/Tooling	L	ļ		Ì			1						
Operator	<u> </u>]			ļ								
Material			}		E								<u>.</u>
Setup				İ			1						·.
Other										!			
Process		ļ					1						
Supplier													
Training			1										ļ
Unapproved													
						F	AUI	T CATE	GORY				<u>: </u>
Landi	ng (Gear			_	General		_			•		•
		Bending			L	Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Concer	atric to	o/s	BOM/Route	L.	Hardwa	re		Over/Under	tolerance	Temperature/Cure
	<u> </u>	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	:t	Weld
		Crushed/0	Crimped,			Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Picklist Print

October-19-12 2:43:40 PM

Work Order ID: 92036

Parent Item:

MS27039-08-13

646.9501

Parent Item Name: 206 Cable Cutter, High

92036

646 9501

Start Date: 19/10/2012

Required Date: 02/11/2012

Start Qty: 1.00

Required Oty: 1:00

392.0000

Loc Code

Loc Code

MS21059-3

Purchased

Purchased

Purchased

No

No

No

Location Loc Qtv Mezz 4067 92 ST307 300 123352 300

110 Each

110

250,0000

AN743-13

BRACKET

<u>Location</u>	<u>L</u> c	oc Oty
ST316		250
123023		50
123301		200
	110	Each

Each

Location Loc Qty ST324 121825 8 ST347 10 123352 10 ST348 2 120242 2

Loc Code

23352

											DQA:	Date:	•
NCR:	Yes	/ No				WORK ORDER NON-C	10:	VFOR	MANCE / UPI	DATE		_	- · · ·
											QA Closed:	Date:	
Work Ord	or.	•				DISPOSITION			·-··	AGAINST DE	PARTMENT	/PROCESS	
Part I	- No					Rework Scrap Use-as-is		Thern	Skid-tube Machining moforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR I	No		*2			Work Order Update]		Large Fab	Composite	j	Supplier	
Root	T				Descri	ption of work order update		nitial	Act	tion	Sign &		
Cause		Date	Step	Qty	,	or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
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Equip/Tooling									li .				
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Landi	ng Ge	ear				General		_			_	·	
		Bending				Bend		Grain			Ovalized		Pressure/Forced
ļ		Centre No	t Concer	tric to	O/S	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
<u> </u>		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
		Crushed/0	Crimped.			Burrs		Instruct	ions Incomplete/l	Jnclear	Part Lost/Mi	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved		_
	ı	leat Trea	t			Countersink		Mislabe	led		Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Page 8

Picklist Print

October-19-12 2:43:40 PM

Work Order ID: 92036 *92036* Parent Item: 646,9501 *646 9501* Parent Item Name: 206 Cable Cutter. High Start Date: 19/10/2012 Required Date: 02/11/2012 Start Qty: 1.00 Required Qty: 1.00 ΛN3-3A Purchased No 110 Each 355.0000 Location Loc Oty Loc Code ST350 355 122416 55 122800 200 123352 100 CCR264SS3-04 Purchased No 110 Each 646.0000 12 *CCR264553 Location Loc Oty Loc Code ST327 200 123352 200 ST331 446 17997 446 CR3212-5-4 Purchased No 110 Each Cherry Rivet

Loc Qty	Loc Code	
200		
200		
168		
68		120308
100		
	200 200 168 68	200 200 168 68

											DQA	: Date:	•
NCR:	Yes	/ No				WORK ORDER NON-O	O	NFORM	MANCE / UPDA	ATE			
									•		QA Closed	: Date:	
Work Ord	~~.					DISPOSITION				AGAINST DE	PARTMENT	T/PROCESS	
WORK OF G	۲.					Rework	7		Skid-tube	Crosstube	1	Water Jet	[Engineering [
Part 1	N۵					Scrap	1		Machining	Small Fab	Dre	od. Eng. Coor.	Engineering Quality
Faiti	10.			 "-	 -	Use-as-is	1		noforming	Finishing	4	ore/Packaging	Other
NCR I	V۵					Work Order Update	┨		· · · · · · · · · · · · · · · · · · ·	Composite	1 100/310	Supplier	Other
	•••					Work order opdate	.		corge ras	eo/nposite[J	3dppner	· · ·
Root		•			Descri	ption of work order update		nitial	Action	n	Sign &	1	
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descript	tion	Date	Verification	QC Inspector
Doc/Data		- "				<u> </u>				<u></u>			
Equip/Tooling					ļ								
Operator													
Material					1 								
Setup						1							
Other													
Process	Ш												
Supplier													
Training													
Unapproved													
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	\vdash	Bending			ļ	Bend	ldash	Grain		_	Ovalized		Pressure/Forced
	-		Centre Not Concentric to O/S		O/\$	BOM/Route		Hardwa			Over/Unde	r tolerance	Temperature/Cure
 	\vdash	Cracks				Broken/Damaged		1	on incomplete		Part Incorre	 	Weld
	$\overline{}$	Crushed/0	Crimped.		<u> </u>	Burrs		1	ions Incomplete/Unc	clear	Part Lost/M	lissing	Wrong Stock Pulled
		Cuffs				Contamination	1	Mainte	nance		Part Moved	j	

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

October-19-12 2:43:40 PM

Work Order ID: 92036

Parent Item:

CCR264SS3-2

646.9501

Parent Item Name: 206 Cable Cutter, High

92036 *646 9501*

Location

106578

108738

112314

ST331

Start Date: 19/10/2012

Required Date: 02/11/2012

Start Qty; 1.00

Required Qty: 1.00

Rivet, Cherry

CR3213-4-1

Purchased

Purchased

Purchased

No

Nο

No

110

Each

154,0000

Loc Code

50.0000

Loc Code

Location Loc Oty ST298 50 123055 40 123078 10 110 Each

400.0000

123055

Location Loc Qty Loc Code ST328 400 123301 400

133301

												DQA:	Dat	e:	
NCR:	⁄es	/ No				WORK ORDER NON-O	O	NFORM	MANCE / UP	DATE				•	
												QA Closed:	Dat	e:	
Work Orde	er:					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		,
Part N	۱۰.					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Pro	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root		•			Descri	ption of work order update	Π	Initial	Act	tion		Sign &	· ·		 -
Cause	\Box	Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verification		QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved											-				
							AUL	T CATE	GORY						
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		Cuffs Heat Trea	t			Contamination Countersink		Mainte Mislabe	nance led			Part Moved Positioned V	Vrong		
	_	Inspectior Ripples in		Tube		Cut Too Short Drill Holes	\vdash	Misread Offset	I			Power Loss/	Surge [Other

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

October-19-12 2:43:40 PM

Work Order ID: 92036

92036

Parent Item:

646.9501

646 9501

Parent Item Name: 206 Cable Cutter, High

Start Date: 19/10/2012

Required Date: 02/11/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08

Screw

Purchased

No

110 Each 1,196,000

<u>Location</u>	Loc Qty	Luc Code
308	168	
122452	168	
ST291	672	
117423	71	
119075	l	
120308	44	
121011	43	
121243	500	
121708	13	
ST305	356	
123265	356	
	110 Ea	ich 18.0000

647.1210

Manufactured No

Purchased

No

Screen

Location Loc Oty Loc Code ST438 18 91438 18 110 8.0000 Each

MS35842-11 Hose Clamp

Location Loc Oty Loc Code ST290A 123023

**

**

123023

										DQA:	Date:	
Yes	/ No				WORK ORDER NON-C	:01	VFOR	MANCE / UP	PDATE	QA Closed:	Date:	
er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
- No					Rework Scrap Use-as-is Work Order Update		f Therm	Machining noforming	Crosstube Small Fab Finishing Composite		· ·	Engineering Quality Other
				Descri	ption of work order update	П	nitial	Ad	tion	Sign &		
	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
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Ш												
Ш			İ									
	er: _ No	No	No. Date Step	No. Date Step Qty	No	DISPOSITION Rework Scrap Use-as-is Work Order Update Date Step Qty Description of work order update or Non-conformance	DISPOSITION Rework Scrap Use-as-is Work Order Update Date Step Qty Description of work order update or Non-conformance Ch	DISPOSITION Rework Scrap Use-as-is Work Order Update Date Step Qty Description of work order update or Non-conformance Chief Eng	DISPOSITION Rework Skid-tube Machining Use-as-is Work Order Update Description of work order update Date Step Qty Or Non-conformance Chief Eng Description	DISPOSITION Rework Skid-tube Crosstube Machining Small Fab Use-as-is Use-as-is Large Fab Composite Description of work order update Date Step Qty Or Non-conformance Chief Eng Description	WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: DISPOSITION Rework Scrap Use-as-is Work Order Update Date Date Step Qty Description of work order update Date Step Qty Description of work order update Or Non-conformance Chief Eng Description Date CA Closed: AGAINST DEPARTMENT Skid-tube Machining Small Fab Pro Thermoforming Large Fab Composite Description Date	WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date: DISPOSITION

			PAU	LI CATEGORY						
Landir	g Gear	General								
	Bending	Bend		Grain		Ovalized		Pressure/Forced		
	Centre Not Concentric to O/S	BOM/Route		Hardware		Over/Under tolerance		Temperature/Cure		
	Cracks	Broken/Damaged		Inspection Incomplete		Part Incorrect		Weld		
[Crushed/Crimped.	Burrs		Instructions Incomplete/Unclear		Part Lost/Missing		Wrong Stock Pulled		
[Cuffs	Contamination		Maintenance		Part Moved		- 		
[Heat Treat	Countersink		Mislabeled		Positioned Wrong		_		
[Inspection Strip in Tube	Cut Too Short		Misread		Power Loss/Surge		Other		
[Ripples in Bend	Drill Holes		Offset						
ĺ	Torque Waves in Extrusion	Drawing		Out of Calibration						
	Turning Sequence Finish			Out of Sequence						
[Wave/Twist in Tube	Folio		Outside Dimensions			· ·			

Process
Supplier
Training
Unapproved

Picklist Print

October-19-12 2:43:40 PM

Work Order ID: 92036

Parent Item: 646.9501

Parent Item Name: 206 Cable Cutter. High

92036 *646 9501*

Start Date: 19/10/2012

Required Date: 02/11/2012

Start Qty: 1.00

**

Required Qty: 1.00

MS27039-08-11

1621

Purchased

Purchased No Location Loc Oty 309 100 122441 100 ST292 46 120833 46 ST307 500 123352 500 110 Each

110

Each

Screw

MS27039-08-09

Purchased

No

No

No

Loc Qty 100 100 110 Each

51.0000

Loc Code

646,0000

Loc Code

56

Purchased

Location Mczz

Location

ST293

11187

117065

Loc Qty 51 51 110 Each

131.0000

Loc Code

SIN

Location Loc Oty Mczz 31 1850 31 ST307 100 123352 100 Loc Code

123352

				DQA:	Date:	•	
ICR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE	-			

									QA Closed:	Date	:
Work Orde	er:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap Use-as-is	Ther	Skid-tube Machining moforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	No		· · · .	=	Work Order Update	<u> </u>	Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	Initial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											·
Other			!								
Process											
Supplier											
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landi	ng Gear				General	AULT CATI	GURT				
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l	Centre No	nt Concer	atric to (7/5	BOM/Route	Hardw	aro.	-	Over/Under	toloranco	Temperature/Cure
	Cracks	A COINCEI	itile to t	³ ,	Broken/Damaged	\vdash	tion Incomplete		Part Incorre	 	Weld
	Crushed/0	Crimped		-	Burrs	-	tions Incomplete/l	Inclear	Part Lost/Mi	<u> </u>	Wrong Stock Pulled
	Cuffs	ormpea.			Contamination	\blacksquare	enance		Part Moved		
İ	Heat Trea	it		<u></u>	Countersink	Mislab			Positioned V	Vrong	• •
	Inspection		Tube		Cut Too Short	Misrea		 	Power Loss/		Other
	Ripples in	•			Drill Holes	Offset			1		
	Torque W		xtrusion	,	Drawing	\vdash	Calibration			······································	
†	Turning S				Finish	1	Sequence				
Ì	Wave/Tw		e		Folio	\vdash	e Dimensions				-

Picklist Print

October-19-12 2:43:40 PM

Work Order ID: 92036 *92036* Parent Item: 646.9501 *646 9501* Parent Item Name: 206 Cable Cutter, High Start Date: 19/10/2012 Required Date: 02/11/2012 Start Qty: 1.00 Required Qty: 1.00 MS27039-1-11 Purchased No 110 Each 137,0000 Location Loc Qty Loc Code Mezz 37 9662 37 ST305 100 123352 100 CR3212-4-4 Purchased No 110 Each Cherry River Location Loc Oty Loc Code ST328 200 123346 200 Purchased No 110 Each Screw Location Loc Oty Loc Code ST302 200 123348 123348 100 123352 100 AN3-10A Purchased No 110 Each 251,0000 ** Bolt Location Loc Oty Loc Code ST351 251 120873 17 122800 234 647.5701 Manufactured No 110 Each 0.0000 ** October-19-12 2:43:40 PM Shop Packet Print Page 12

							DQA:	Date:	
NCR: Yes	s / No			WORK ORDER NON-C	CONFORI	MANCE / UPDATE	QA Closed:	Date:	
Work Order:				DISPOSITION		AGAIN	IST DEPARTMENT	/PROCESS	,
Part No.				Rework Scrap Use-as-is Work Order Update	4 1	Skid-tube Crosstu Machining Small Finish Large Fab Compos	Pro ing Rec/Sto	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Description of work order update	Initial	Action	Sign &		
Cause	Date	Step	Qty	or Non-conformance	Chief Eng	Description	Date	Verification	QC Inspector
Doc/Data									• .
Equip/Tooling]								
Operator	_]					,			
Material	_						}		
Setup				1					
Other									
Process									
Supplier		1							
Training	1					ł			

FAULT CATEGORY Landing Gear General Bending Bend Grain Ovalized Pressure/Forced Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Temperature/Cure Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Cuffs Contamination Maintenance Part Moved Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Cut Too Short • Other Power Loss/Surge Misread Ripples in Bend Drill Holes Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence Wave/Twist in Tube Folio Outside Dimensions

Unapproved

October-19-12 2:43:40 PM

Work Order ID: 92036

646.9501

92036 *646 9501*

Parent Item Name: 206 Cable Cutter. High

Parent Item:

No

110

Each

Start Date: 19/10/2012

Required Date: 02/11/2012

Required Qty: 1.00

Magnabond 6398 Part A (One 4 oz can)

Magnabond 6398 Part B (One 4 oz can)

600.0991

600.1012

600.0990

Purchased

Purchased

No

110

110

Each

Each

0.0000

NCR:	Yes	/ No				WORK ORDER NON-O	100	VFORM	MANCE / UPI	DATE		•		•	
												QA Closed:	Da	ite:	
Work Orde	er:					DISPOSITION				AGAINST (DΕ	PARTMENT	PROCESS		
Part N	_					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		4	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root					Descri	ption of work order update	Ī	nitial	Act	ion		Sign &			
Cause		Date	Step	Qty	·	or Non-conformance	Ch	ief Eng	Descr	iption		Date	Verificatio	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved						·				·.					
							AUL	T CATE	GORY			-			
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	_		crimped.			Burrs		4	ions Incomplete/U	Jnclear		Part Lost/Mi	ssing		Wrong Stock Pulled
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Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

DQA:

Positioned Wrong

Power Loss/Surge

Other

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

SW Rol

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DETAIL B			646,9502 646,9501	204 C ABLE CUTERS YELDWA		
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	5 35 30 M 949 SEREW	MS7705F-1 13	COMPACINE CONTRACTOR	GCEALBICE CA. 92		
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1 4	ΔF	PICAL	DW	G N	D. 646,9500 REVIN/C BY PREPARED S. HUFF	DATE: 12/23/09 EFFECT ON DWG
1 11 + -	STRIES, INC.	DW	G T	ITLE: 206 CABLE CUTTERS		
INDUSTRIES, INC.		311123, 11101	APPRE	IVED BY	ENGR Joan Daniel James acc	Manu France EFFI CURRENT ORDER
A	ANSA -ADI -RE\		REA	NDSA	HARDWARE REVISIONS FROM FIRST INSTALL	
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	Y		·	ı		
51	A	601.3155	8	8	BOLT	AN3-10A
50	A -	.601.3153	5.	_5_	SCREV	MS24694S8
V41	ĴR ₹	601.2893	" <u>4</u> 3 ₃	<u>4</u> 43)	SCREW	M\$27039-0811
,	Ŝ	601,2973	54.1	\$54 ₇₀	LOCKNUT	MS21042-08
l is≌	şRi	601.2826	88	8	BOLT	AN3-11A
16	R	601.2764	127	127	WASHER	NAS1149FN832P
			9502	9501		
F/N	TC	PART NUMBER	Q	ΓΥ	DESCRIPTION	MATERIAL/SPECIFICATION
DOC	UME	NTS EFFECTED		MDL	☐ MAJOR ☐ INSTALL INSTRUC ☐ ICA ☐ FMS ☐ B☐M ☐ MAJOR	CATEGORY DER REVIEW REQUIRED MINOR D YES MINO

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	ENGINE	ERING CHANGE	NOTICE NO.	027	'36		OF 1
APICAL	DWG N	10. 646.9500 F	REV:N/C PREPAR	ED S. HUFI	F DATE: 0		T ON DWG.
INDUSTRIES, INC.	DWG T	ITLE:	206 CABLE	CUTTERS	KIT		
11120011120, 1110.	APPROVED B	SYI ENGR 3can	Admil Jo	nsex of	Mary Ly	EFFI CURRENT	ORDER
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON	N: CORRECTED PARTS		J ·			
				1			
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47 8 60 1607		VACUED			NAS1149F0332P		
17 R 601.1607			***		NAS1149FN832P		
16 R 601.2764	9502 9501	73					
F/N TC PART NUMBER	QTY	DESCRIPTION			MATERIAL/S	SPECIFICATION	
DOCUMENTS EFFECTED		IXI INSTALL INSTRUC	IXI ICA □ FMS IX	CHANGE	CATEGORY DE	R REVIEW REQUIRE	D

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